

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022278**Date Inspected:** 24-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:** Tian Lei, Liu Fa Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Trial Assembly

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 08609. The member(s) is/are identified as Tower Ladder components as identified below with the following identifying weld no.(s):

1. WSD1-RA6-9-2-1~4, WSD1-RA6-9-1-1~4, WSD1-RA6-13-1-1~4.
2. WSD1-RA6-11-1~6, WSD1-RA6-4-1~7, WSD1-RA6-14-1/2, NSD1-LASA6-9-2-1~16.
3. WSD1-LASA6-13-1~3, WSD1-LASA6-14-1~3, WSD1-LASA6-1-1~26.
4. WSD1-LASA6-7-1~18, ESD1-RA6-12-1-1~4, ESD1-RA6-12-2-1~4.
5. NSD1-RA6-5-2-1~4, NSD1-RA6-5-1-1~4, NSD1-RA6-8-1-1~4.
6. NSD1-RA6-8-2-1~4, NSD1-RA6-6-1~4, SSD1-RA6-7-1~4.
7. ESD1-RA6-10-1~6, ESD1-RA6-2-1~7, NSD1-RA6-3-1~7, SSD1-LASA6-8-1~18.
8. SSD1-RA6-1-1~7, SSD1-LASA6-15-1~3, SSD1-LASA6-6-1~3, SSD1-LASA6-11-1~26.
9. NSD1-LASA6-5-1-1/2, NSD1-LASA6-5-2-1/2, NSD1-LASA6-2-1-1/2.

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10. NSD1-LASA6-2-2-1/2, SSD1-LASA6-10-1~16, SSD1-LASA6-16-1-1~52.
11. SSD1-LASA6-16-2-1-1~52, NSD1-LASA6-4-1-26, ESD1-LASA6-3-1~26.
12. NSD1-LASA6-12-1-1~54, NSD1-LASA6-12-2-1~54, NSD1-LASA6-9-1-1~16.

Bay Number 1

SMAW welding of fillet welds located on Bike Path Handrail component identified as BKR-NS-3 for miscellaneous 4mm welds attaching P-45 to P-171 and P-171 to P-40 parts. Welder is identified as welder no. 049769. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-B-P-2112.

SMAW welding of complete joint penetration welds located on Traveler Rails component identified as 20TR2-038 as identified on weld repair data sheet B-WR-20482 for repaired complete joint penetration welds identified as weld no.(s): 009, 011, & 015. Welder is identified as welder no. 049769. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-1G(1F)-repair.

SMAW welding of complete joint penetration welds located on Traveler Rails component identified as 20TR2-036 as identified on weld repair data sheet B-WR-20481 for repaired complete joint penetration welds identified as weld no.(s): 011 & 015. Welder is identified as welder no. 054467. The welding variables recorded by ZPMC QC identified as Tian Lei appeared to comply with applicable WPS(s) WPS-345-SMAW-1G(1F)-repair.

Bay Number 8

This QA inspector performed VT/MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 08611. The member(s) is/are identified as OBG Bike Path components as identified below with the following identifying weld no.(s):

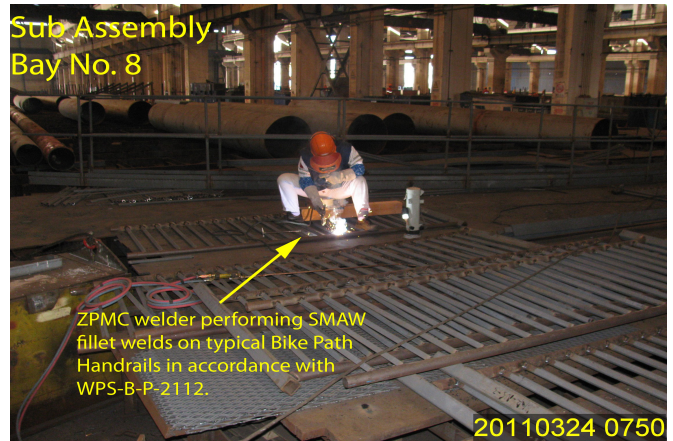
1. BK004A5-062-002, 003, 006, & 008.
2. BK004A3-062-002, 003, 007, & 010.
3. BK4SD1-060-007~013.
4. BK4SD1-060-015, 016, 017, 019, 020, 025, & 026.

SMAW welding of plug welds located on Bike Path component identified as BK004A2-060 weld no.(s) 014, 015, 017, 019, & 020. Welder is identified as welder no. 037840. The welding variables recorded by ZPMC QC identified as Liu Fa Wen appeared to comply with applicable WPS(s) WPS-B-T-2112-plug.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

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Summary of Conversations:

Pertinent conversations are included in the body of the report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By: Hernandez,Rene

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer